

Date: Thursday, 3/23/2006 3:13:05 PM
User: COSS systems

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LEFT ARM WELDMENT
Job Number :	26360		
Estimate Number :	12106		
P.O. Number :	NIA	Part Number :	D33541
This Issue :	3/23/2006	S.O. No. :	NIA
Prsht Rev. :	NC	Drawing Number :	D3354 REV.A
First Issue :	NIA	Project Number :	N/A
Previous Run :	NIA	Drawing Revision :	A
	Type :	Material :	NIA
	MACHINED PARTS	Due Date :	3/30/2006
Written By :	<i>SEE COMMENT BELOW</i>		Qty: 8 Um: Each
Checked & Approved By :	<i>SEE ABOVE USER & DATE</i>		
Comment :	est rev. A New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4140HR1000	Inventory
Comment: Qty.: 1.0763 f(s)/Unit Total: 8.6100 f(s) AISI 4140 ROUND BAR Dia. 1.00" batch: <i>M18423</i>		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blank 12.30" long <i>AD 06.03.24. 8</i>		
3.0	LATHE CONV.	CONVENTIONAL LATHE
Comment: CONVENTIONAL LATHE Turn as per Dwg D3354 <i>AD 06/03/27 8</i>		
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE 1- Mill as per dwg D3354 2-Debur as per dwg D3354 <i>AD 06/03/28 8</i>		
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>AD 06/03/28 8</i>		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/13,
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LEFT ARM WELDMENT

Job Number: 26360

Part Number: D33541

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06-03-28

8

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 428

06/3/30

(8)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/31

Job Completion



06-03-30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

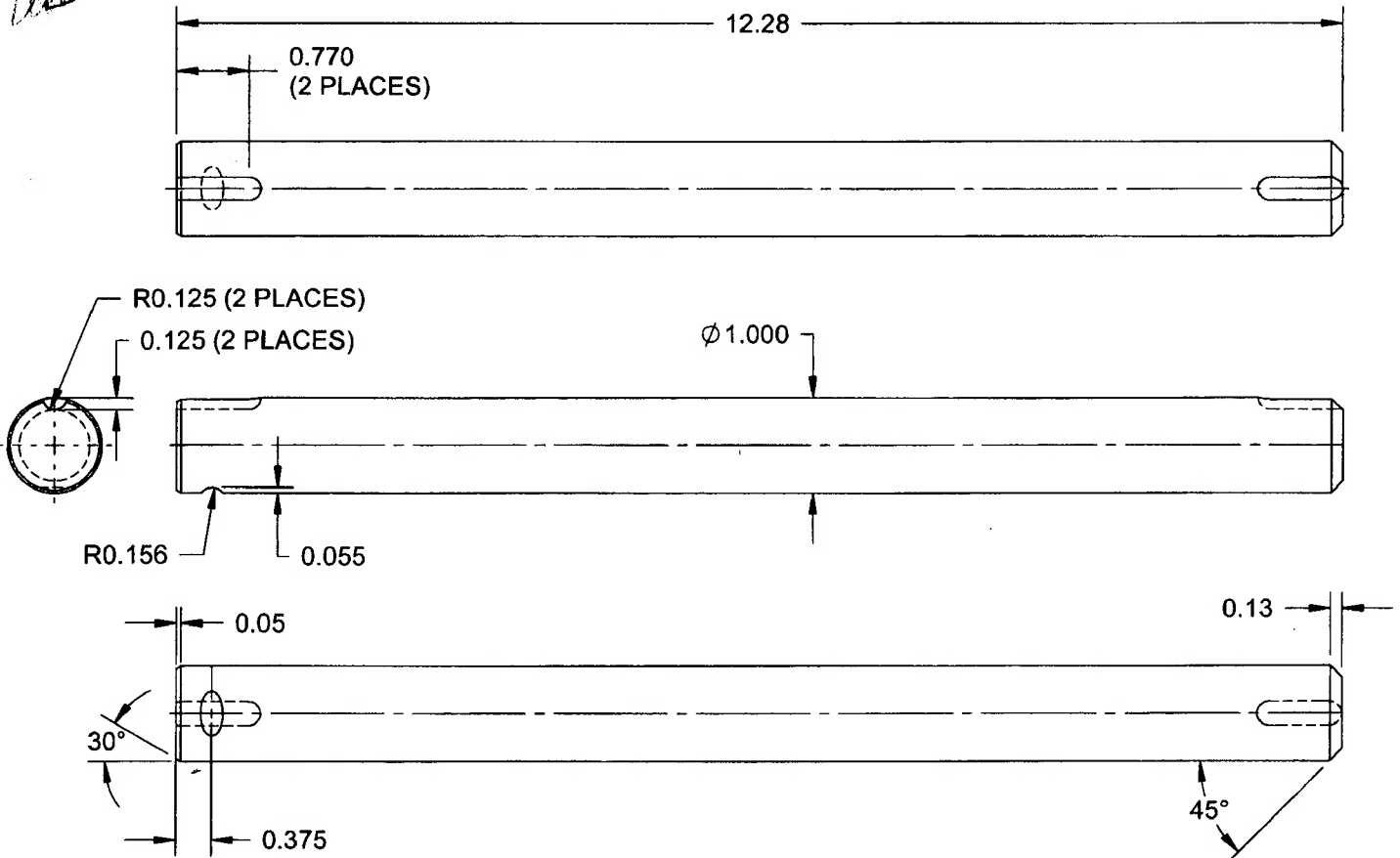
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3354	REV. A SHEET 3 OF 7
DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
06/03/07**D3354-1 INNER SHAFT****NOTES:**

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PART AEROSPACE LTD. Description: <i>Left Arm Weldment</i> Inspection Dwg: <i>3354</i> Rev: <i>A</i>	Work Order: <i>26360</i> Part Number: <i>D33541</i>
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Work Order: 26360

Description: Left Arm Weldment

Part Number: D33541

Inspection Dwg: 3354 Rev: A


Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Prototype

[illegible]

Measured by: 
Date: 06/03/28

Audited by: J.L.
Date: 06.03.28

Prototype Approval.

Date:

Rev	Date	Change
1		New Issue

Revised by	Approved
KJ/RF	